

Work Order ID 78704

\*78704\*

Page 1

January-13-12 7:04:46 AM

Item ID: D412-694-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Spacedoors

Start Date: 12/01/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: M.L.J. Date: 12/01/13 Tooling:

Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

M.L.J.

M.L.J. 14-10-21

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-694-011 CHG005

DAS  
06  
9-89

100 12 130

110

0.00

\*110\*

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

D3119-041 Cover Assembly

D3119-042 Cover Assembly

D3140-05/-07 Door (for D412-694-01/-03)

D3140-06/-08 Door (for D412-694-02/-04)

Supplier: Delastek

Ship to Delastek

Qty Part Number Description

1 D3140-5-7 Doubler Kit

1 D3140-6-8 Doubler Kit

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78704

**\*78704\***

Page 2

January-13-12 7:04:46 AM

Item ID: D412-694-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Spacedoors

Start Date: 12/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs  Memo Ensure material certification is attached	0.00  0.00							
130 <b>*130*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo Visual inspection. Check for void spot and pins. Check over all dimensions and windows as per Dwg D3140. Bring to composite room for assembly	0.00  0.00							
140 <b>*140*</b> Packaging Packaging	Pick Kit  Memo	0.00  0.00							

1x SP14-10-21  
8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78704

January-13-12 7:04:46 AM

**\*78704\***

Page 3

Item ID: D412-694-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Spacedoors  
 Start Date: 12/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 26/01/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00							
			DAS 03 9-89						OCT 27 2014
160 <b>*160*</b> Packaging Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D412-694-011 Location: _____ PPP Rev: _____	0.00  0.00							
			DAS 03 9-89						OCT 27 2014
170 <b>*170*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							
									MLJ 14-10-27

W41027

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January-13-12 7:04:49 AM

Page 1

Work Order ID: 78704

\*78704\*

Parent Item: D412-694-011

\*D412-694-011\*

Parent Item Name: Spacedoors

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A05.04.27New IssueKJ/RF

IPP Rev:B 07-01-26 Added DSI 9363-011 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DAS 05 9-89 D412-694-01 *D412-694-01*		Manufactured	No		140 110		Each	0.0000	1	1		78705	2
Door Assembly													
DAS 05 9-89 D412-694-02 *D412-694-02*		Manufactured	No		140 110		Each	0.0000	1	1		123759	2
Door Assembly													
DAS 05 9-89 D412-694-03 *D412-694-03*		Manufactured	No		140 110		Each	0.0000	1	1		78707	2
Door Assembly													
DAS 05 9-89 D412-694-04 *D412-694-04*		Manufactured	No		140 110		Each	0.0000	1	1		78708	2
Door Assembly													
DAS 05 9-89 DSI 9363-011 *DSI-9363-011*		Manufactured	No		140 110		Each	0.0000	1	1		87462	2
Shim													
DAS 05 9-89 BSP45 *BSP45*		Purchased	No		140		Each	177.0000	48	48		m 120417	2
Commercial Rivet													

57282

Location

Loc Qty

Loc Code

ST284

177

118614

177

DAS  
38  
9-89

DAS  
05  
9-89

OCT 21 2014

(8.666 F)  
OCT 27 2014

Batch: 39182

(A3116-9-0520) cut 2 at 52.00" per kit.

4.10.27

A3116-9

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 78704

**\*78704\***

Parent Item: D412-694-011

**\*D412-694-011\***

Parent Item Name: Spacedoors

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

~~D2126~~

Manufactured No

140 f

575.7858 12.1666 12.1666

DAS  
26  
9-89

**\*D2126\***

Seal

DAS  
06  
9-89

DAS  
38  
9-89

383817

Location

Loc Qty

Loc Code

ST405

575.78579

57106

4

68336

71.78579

76094

500

(D2126-0730) cut qty (2) at 73.00" as per dwg \*\*\*per kit\*\*\*

~~D3090-1~~

Manufactured No

140 Each

23.0000 4 4

DAS  
26  
9-89

**\*D3090-1\***

Shim 0.250

DAS  
06  
9-89

DAS  
38  
9-89

ST017

Location

Loc Qty

Loc Code

ST025

23

18037

23

D3090-3

Manufactured No

140 Each

24.0000 4 4

DAS  
26  
9-89

**\*D3090-3\***

Shim 0.125

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST025

24

18040

24

D3108-1

Manufactured No

140 Each

6.0000 2 2

\*\*

OCT 21 2014

**\*D3108-1\***

Decal

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST026

6

55562

1

72047

5

DAS  
26  
9-89

January-13-12 7:04:50 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 78704

**\*78704\***

Parent Item: D412-694-011

**\*D412-694-011\***

Parent Item Name: Spacedoors

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

DAS  
26  
9-89

D3108-2

Manufactured No

140 Each

3.0000

\*\*

2 → (2)

B83567

**\*D3108-2\***  
Decal

DAS  
03  
9-89

Location

Loc Qty

Loc Code

ST026

3

55563

3

DAS  
26  
9-89

D3108-3

Manufactured No

140 Each

1.0000

\*\*

4 (4)

B117901

**\*D3108-3\***  
Decal

DAS  
03  
9-89

Location

Loc Qty

Loc Code

CA

1

50374

1

DAS  
26  
9-89

D3108-5

Manufactured No

140 Each

7.0000

\*\*

4 (4)

B110719

**\*D3108-5\***  
Decal

DAS  
03  
9-89

Location

Loc Qty

Loc Code

ST026

7

55566

7

D3108-7

Manufactured No

140 Each

14.0000

\*\*

2 2

OCT 21 2014

**\*D3108-7\***  
Decal

DAS  
03  
9-89

Location

Loc Qty

Loc Code

ST026

14

36723

14

DAS  
26  
9-89

24

January-13-12 7:04:50 AM

Shop Packet Print

Page 3

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

January-13-12 7:04:50 AM

Page 4

Work Order ID: 78704

\*78704\*

Parent Item: D412-694-011

\*D412-694-011\*

Parent Item Name: Spacedoors

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3116-1 Manufactured No 140 f

74.6700 8.3333 8.3333

DAS

\*D3116-1\*

Seal

DAS  
03  
9-89

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST414

74.67

24697

74.67

(D3116-1-0500) cut qty (2) at 50.00" as per dwg  
\*\*\*per kit\*\*\*

D3116-3 Manufactured No 140 f

107.6667 8.3333 8.3333

\*D3116-3\*

Seal

DAS  
03  
9-89

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST414

107.6667

17296

50

27240

7.6667

62091

50

(D3116-3-0500) cut qty (2) at 50.00" as per dwg  
\*\*\*per kit\*\*\*

D3118-3 Manufactured No 140 Each

2.0000

\*D3118-3\*

Sign Assembly

DAS  
03  
9-89

Location

Loc Qty

Loc Code

ST027

2

73220

2

D3118-5 Manufactured No 140 Each

3.0000

\*D3118-5\*

Sign Assembly

DAS  
03  
9-89

Location

Loc Qty

Loc Code

ST027

3

64831

3

January-13-12 7:04:50 AM

Shop Packet Print

Page 4

OCT 21 2014

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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January-13-12 7:04:50 AM

Work Order ID: 78704

\*78704\*

Parent Item: D412-694-011

\*D412-694-011\*

Parent Item Name: Spacedoors

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3128-1

Manufactured No

140 Each

1.0000

\*\*

DAS  
28  
9-89

\*D3128-1\*

Shim

DAS  
03  
9-89

Location

Loc Qty

Loc Code

ST235A

1053617

1

1

122946

140 Each

4.0000

2

2

\*\*

DAS  
28  
9-89

D3144-15

Manufactured No

\*D3144-15\*

Doubler

Location

Loc Qty

Loc Code

CA

67696

4

4

140 Each

7.0000

\*\*

DAS  
28  
9-89

D3300-1

Manufactured No

\*D3300-1\*

Window

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST209

56108

7

7

140 Each

1.0000

\*\*

DAS  
28  
9-89

D412-694-015

Manufactured No

\*D412-694-015\*

Replacement Window

shop at 2  
12terdike  
5/01/6798

pick

Location

Loc Qty

Loc Code

FG060

59823

1

1

128278

OCT 21 2014

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries





DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

COPY

TO

COPY

TO

78704 MJS  
12/10/13

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



78704

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND  
ALODINE PER DART QSI 005 4.1



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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

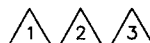
[illegible]

RELEASED

06.11.13

**SECTION B-B**

**D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)**  
**D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)**  
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)



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06.10.06

DOOR

NTS

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

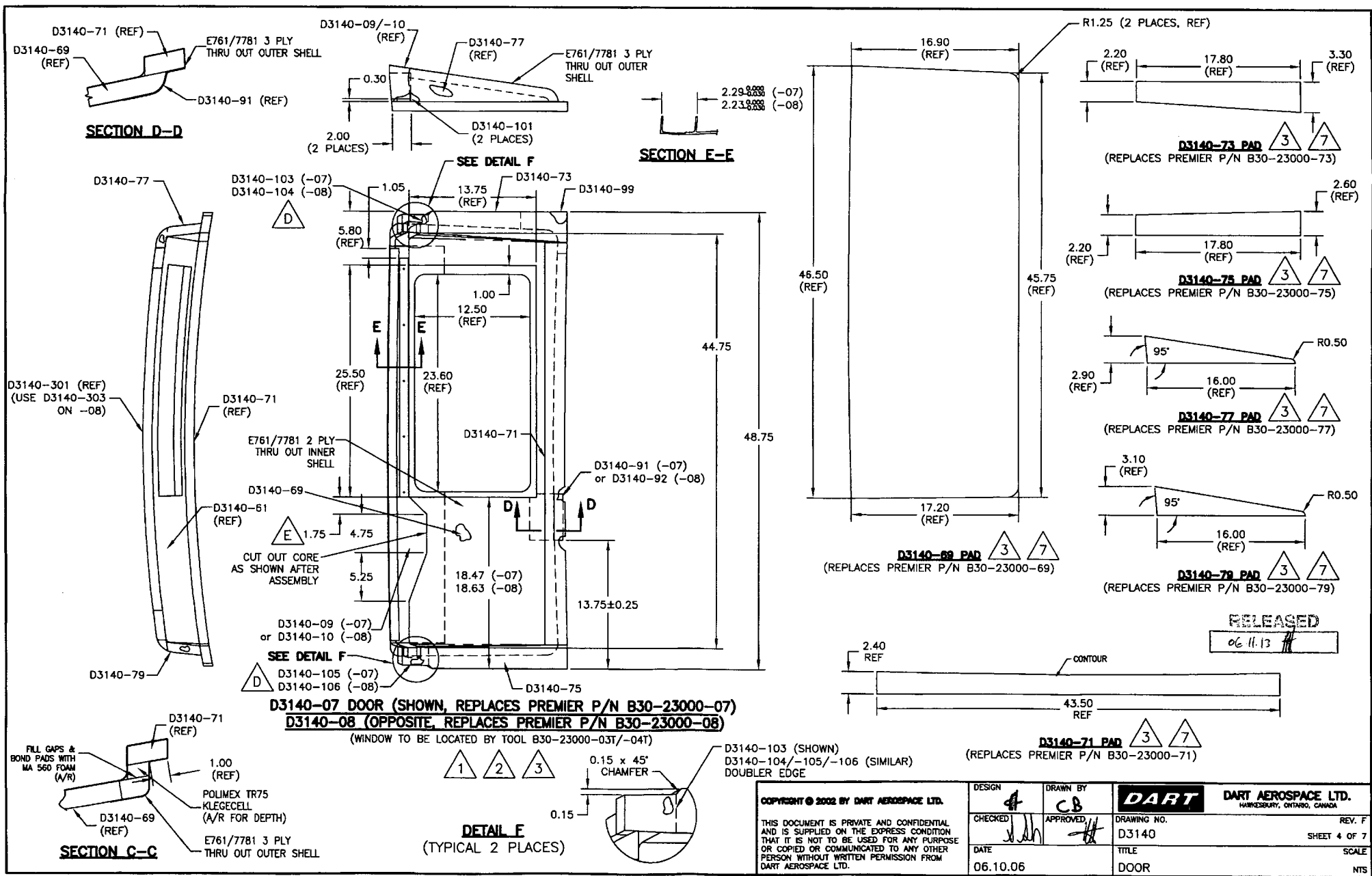
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78704



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

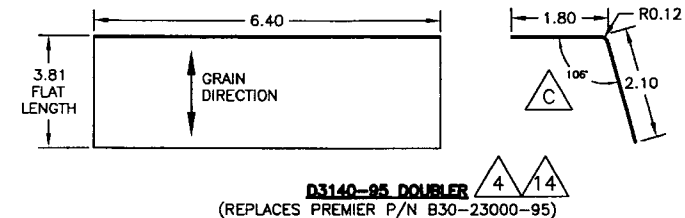
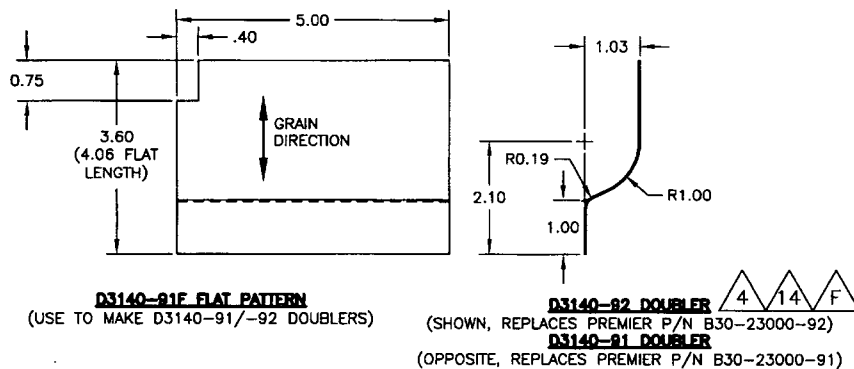
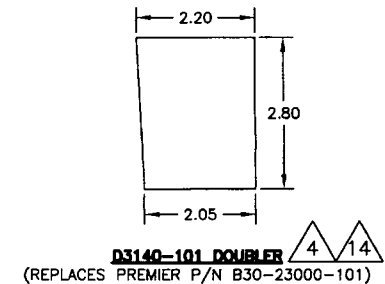
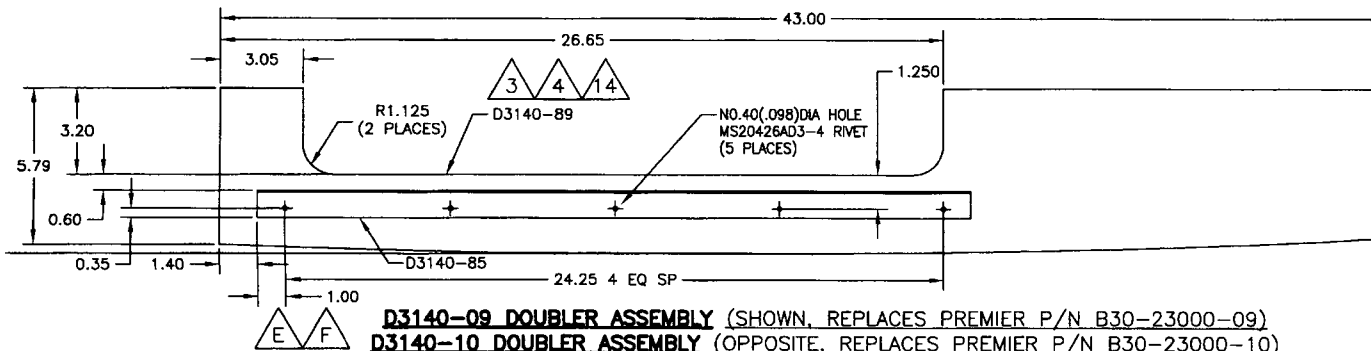
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

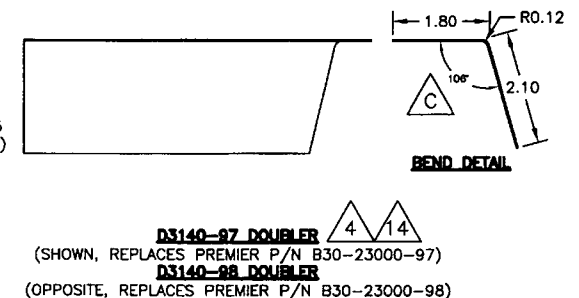
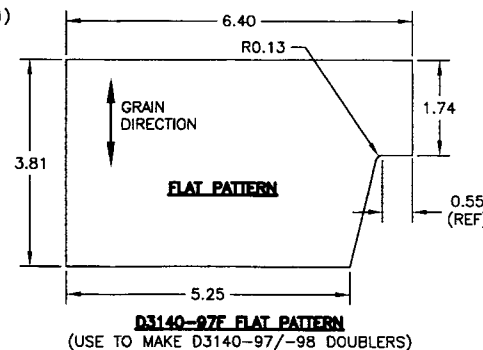
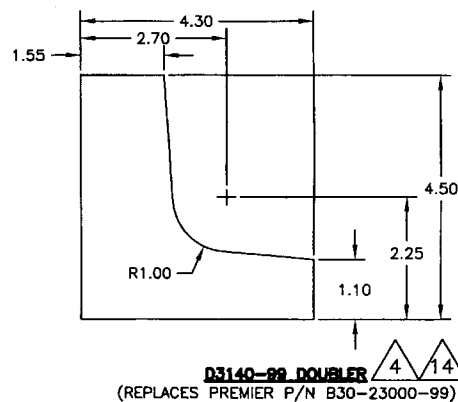
**NOTE:** Date & initial all entries



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06.11.13



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		DATE	06.10.06	DRAWING NO.		D3140	SHEET 5 OF 7
				TITLE		DOOR	SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

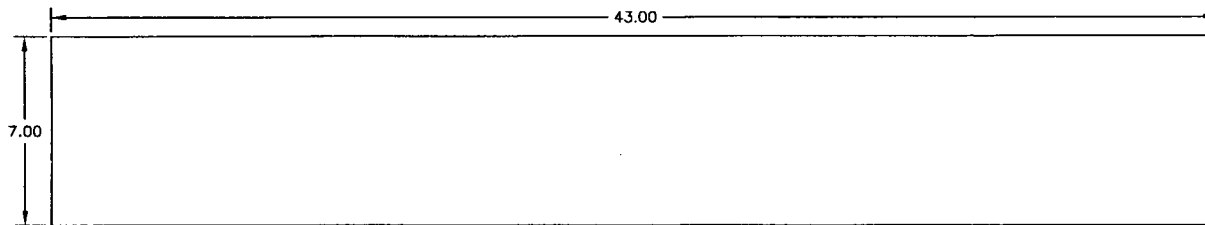
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

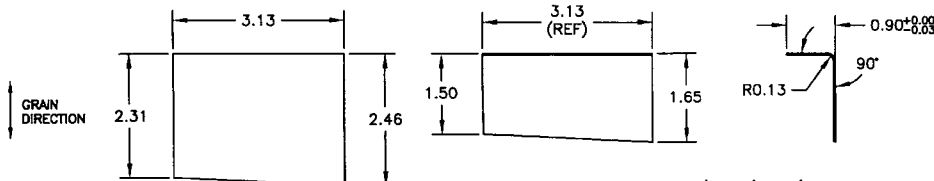
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

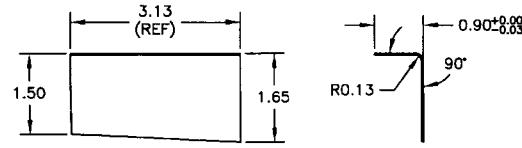
78704



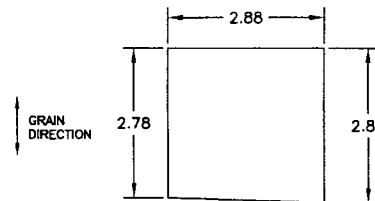
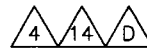
**D3140-87 DOUBLER**   
(REPLACES PREMIER P/N B30-23000-87)



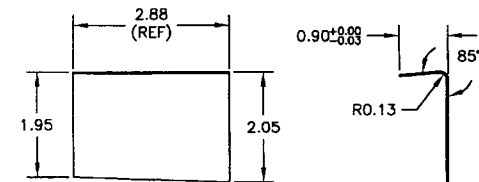
**D3140-105F FLAT PATTERN**  
(USED TO MAKE D3140-105/-106 BRACKETS)



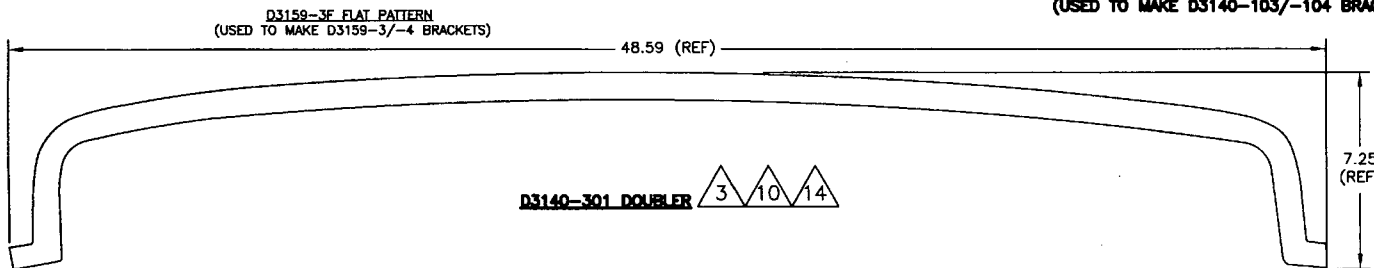
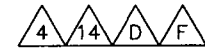
**D3140-105 DOUBLER**  
**D3140-106 OPPOSITE**



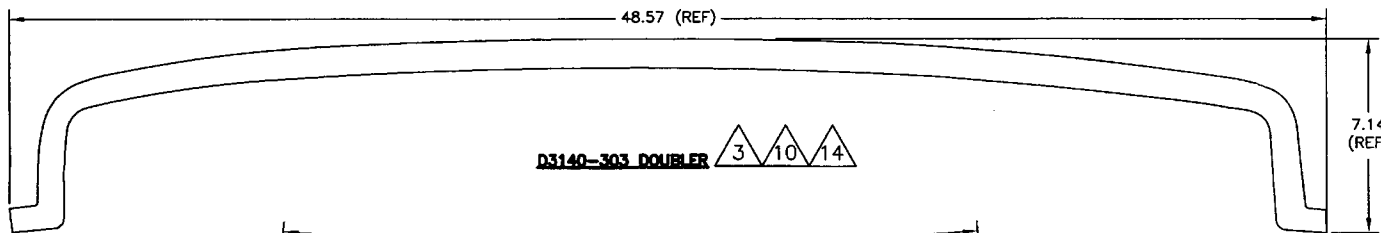
**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)



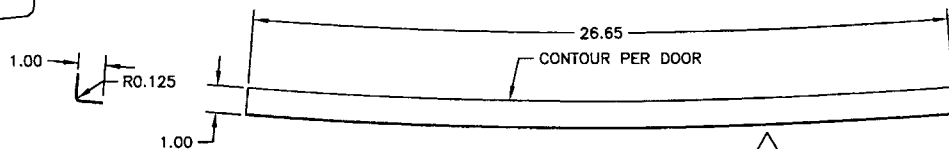
**D3140-104 DOUBLER**  
**D3140-103 OPPOSITE**



**D3140-301 DOUBLER**



**D3140-303 DOUBLER**



**D3140-85 ANGLE**   
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

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DESIGN

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DRAWN BY

CB

CHECKED

APPROVED

DATE

06.10.06

**DART**

**DART AEROSPACE LTD.**  
HAMPSHIRE, ONTARIO, CANADA

DRAWING NO.

D3140

TITLE

DOOR

REV. F

SHEET 6 OF 7

SCALE

NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

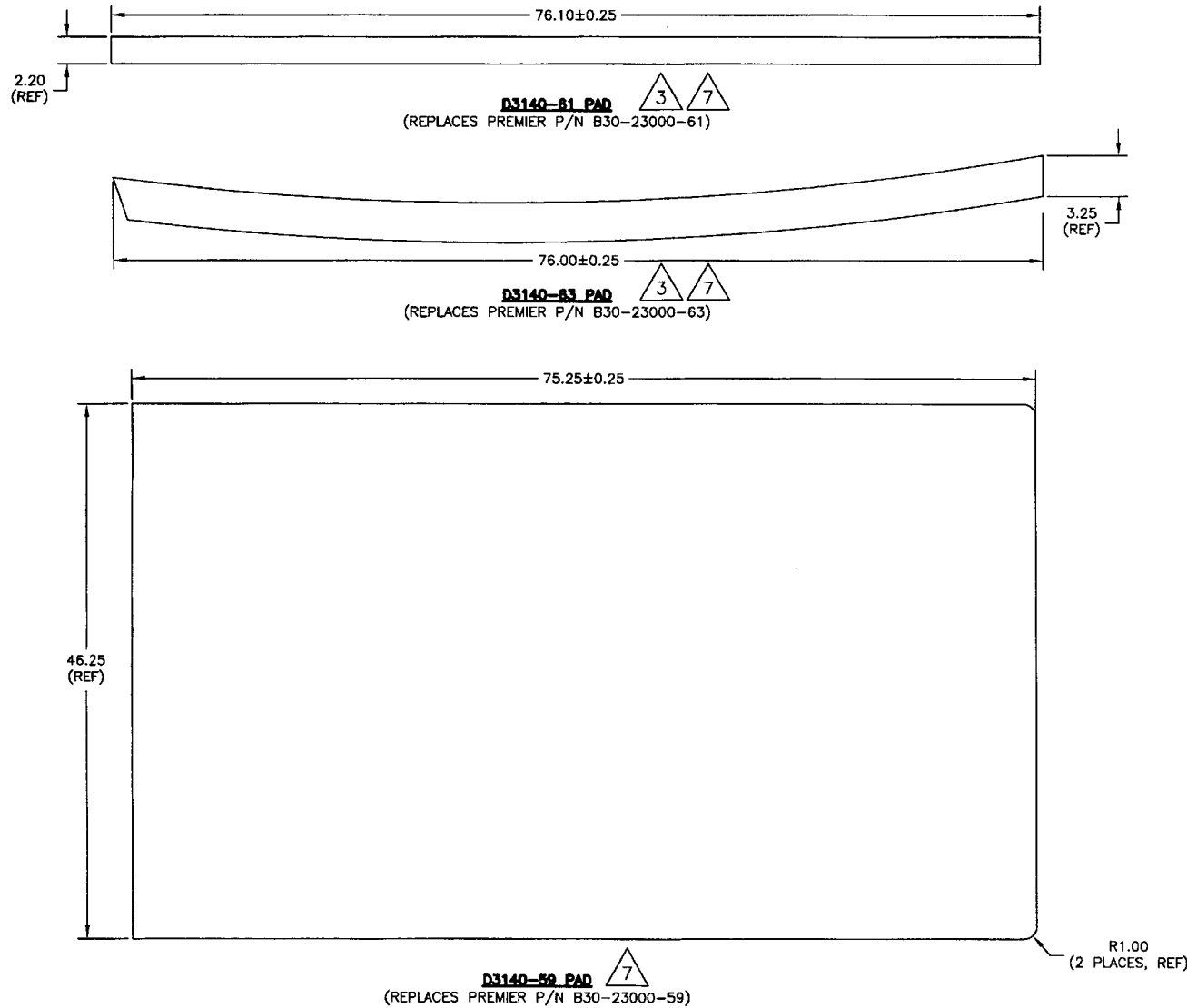
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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06.11.13

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		DATE 06.10.06	TITLE DOOR	REV. F SHEET 7 OF 7 SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 6. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X								D412-694-011	SPACEDOOR™ INSTALLATION
	X							D412-694-013	PANEL INSTALLATION (OPTIONAL)
4		X						D412-694-015	REPLACEMENT WINDOW KIT
			X					D412-694-017	BEARING OVERHAUL KIT
1				X				D412-694-01	DOOR ASSEMBLY
1					X			D412-694-02	DOOR ASSEMBLY
1						X		D412-694-03	DOOR ASSEMBLY
1							X	D412-694-04	DOOR ASSEMBLY
2								D2126-0730	SEAL
4								D3090-1	SHIM
4								D3090-3	SHIM
2								D3108-1	DECAL
2								D3108-2	DECAL
4								D3108-3	DECAL
4								D3108-5	DECAL
2								D3108-7	DECAL
						1	1	D3110-1	ESCUTCHEON
						1	1	D3110-3	HANDLE
				1	1			D3110-5	HANDLE ASSEMBLY
						1	1	D3111-041	PLATE ASSEMBLY
						2	2	D3112-1	GUIDE
						1	1	D3113-1	SPRING
						1	1	D3114-1	PIVOT
				1	1			D3115-1	BRACKET
2								D3116-1-05007	SEAL
						1	1	D3116-11-0180	SEAL
2								D3116-3-05007	SEAL
						1	1	D3116-5-0680	SEAL
				1	1			D3116-7-0680	SEAL
				1	1			D3116-9-0770	SEAL
		1						D3117-1-0980	SEAL RETAINER
		1						D3117-3-0980	SEAL FILLER
4								D3118-3	SIGN ASSEMBLY
4								D3118-5	SIGN ASSEMBLY
						1		D3119-041	COVER ASSEMBLY
							1	D3119-042	COVER ASSEMBLY
						1		D3120-1	COVER
							1	D3120-2	COVER
						1		D3120-3	COVER
							1	D3120-4	COVER
				3	3			D3121-041	BRACKET ASSEMBLY ("ROLLER")
				1				D3121-043	BRACKET ASSEMBLY ("ROLLER")
					1			D3121-044	BRACKET ASSEMBLY ("ROLLER")
			7					D3121-21	SCREW

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Revision: B

Date: 04.10.07

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D412-694

Page 17 of 18

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
					1		1	D3144-121	DOUBLER
					1			D3144-123	DOUBLER
				1	1			D3144-13	DOUBLER
				1				D3144-3	DOUBLER
						1		D3145-1	HINGE BRACKET
							1	D3145-2	HINGE BRACKET
						1		D3146-1	HINGE BRACKET
							1	D3146-2	HINGE BRACKET
						2	2	D3147-1	PIN
				2	2			D3148-1	CLEVIS
						2	2	D3149-1	STRIKER PLATE
						2	2	D3150-1	GUIDE
				1	1			D3151-041	DOUBLER ASSEMBLY
				1				D3152-041	BRACKET ASSEMBLY
					1			D3152-042	BRACKET ASSEMBLY
1								D3153-11	PANEL
1								D3153-12	PANEL
1								D3153-13	PANEL
1								D3153-14	PANEL
1								D3153-15	PANEL
1								D3153-16	PANEL
						1	1	D3154-1	KEY
				1	1			D3155-041	BRACKET ASSEMBLY
				1	1			D3155-042	BRACKET ASSEMBLY
				2	2			D3156-1	BRACKET
						2	2	D3157-1	SPACER
						3	3	D3159-041	BRACKET ASSEMBLY
						1		D3159-043	BRACKET ASSEMBLY
							1	D3159-044	BRACKET ASSEMBLY
				12	12			D3162-041	BRACKET ASSEMBLY
				1				D3163-041	COVER ASSEMBLY
					1			D3163-042	COVER ASSEMBLY
				1				D3183-041	BRACKET ASSEMBLY ("ROLLER")
					1			D3183-042	BRACKET ASSEMBLY ("ROLLER")
			2					D3183-045	BEARING ASSEMBLY
				1	1			D3203-1	HANDLE ASSEMBLY
2								D3300-1	WINDOW
				2	2			D3308-1	DOUBLER
				55	55	21	21	80-005-2-8	INSERT (OR SL2052-3-4)
60								A6K75	RIVNUT
				10	10			AN525-10R6	SCREW
				8	8	4	4	AN525-10R7	SCREW
						8	8	AN960JD10	WASHER
				18	18	4	4	AN960JD10L	WASHER
				13	13	32	32	AN960JD10LL	WASHER
				6	6			AN960JD416L	WASHER
						4	4	AN960JD6L	WASHER
				6	6			AN960JD8	WASHER
						2	2	AN960JD8L	WASHER

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Date: 04.10.07



Qty 011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
						2	2	AN960JD8LL	WASHER
						10	10	ASL4-632-80	INSERT
				87	87	47	47	BSP45	RIVET
						14	14	FW10-032	WASHER
						6	6	FW4-032	WASHER
				12	12			M7885/2-4	RIVET (OR CR3213-4-3)
						3	3	M7885/3-4	RIVET (OR CR3212-4-3)
						2	2	MS20392-1C11	PIN
						5	5	MS20392-2C15	PIN
				2	2			MS20392-2C17	PIN
				2	2	2	2	MS20392-2C9	PIN
				2	2			MS20392-3C21	PIN
				8	8			MS20426AD3	RIVET
				20	20			MS20426AD4	RIVET
				A/R	A/R			MS20995-C20	LOCKWIRE
						6	6	MS21042L06	NUT
				6	6	2	2	MS21042L08	NUT
						5	5	MS21042L3	NUT
				4	4			MS21042L4	NUT
				4	4			MS21072-L3	NUTPLATE
				6	6	9	9	MS24665-151	COTTER PIN
				4	4			MS24693-S271	SCREW
						2	2	MS24694-C4	SCREW
				4	4			MS24694-C5	SCREW
			1					MS24694-S101	SCREW
				6	6			MS24694-S5	SCREW
				18	18			MS24694-S50	SCREW
						4	4	MS24694-S56	SCREW
						2	2	MS24694-S6	SCREW
						4	4	MS24694-S60	SCREW
				4	4			MS24694-S98	SCREW
						2	2	MS25281-R6	CLAMP
				2	2	2	2	MS27039-1-05	SCREW
				14	14	12	12	MS27039-1-06	SCREW
				13	13	6	6	MS27039-1-08	SCREW
						2	2	MS35206-231	SCREW
				2	2			MS35275-233	SCREW
				2	2			MS35649-264	NUT
						4	4	MS35650-305T	NUT
				2	2			MS35650-3252	NUT
				2	2	3	3	MS51859-7	WASHER
						4	4	NAS1169-10L	WASHER
						1	1	NAS388-6-12P	SCREW
	60					14	14	NAS388-6-8P	SCREW
	60					15	15	NAS391B6P	WASHER
				7	7			NAS43DD3-10	SPACER
				6	6			NAS43DD3-14	SPACER
						2	2	NAS43DD3-40	SPACER

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Revision: B

Date: 04.10.07



DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9309	REV. A SHEET 1 OF 2
DATE 05.09.26		TITLE SEAL KIT	SCALE NTS
A	05.09.26	NEW ISSUE	

## DART SERVICE INSTRUCTION

TO AMEND IIN-D412-694 REV. B

REF. CANADIAN STC: SH05-10

REF. FAA STC: SR02086NY

TO CLOSE THE GAP BETWEEN AIRCRAFT AND D412-694-01/-02 DOOR ASSEMBLY IT IS ACCEPTABLE TO INSTALL D3116-9-0520 SEAL AS SHOWN BELOW IN LIEU OF INSTALLING THE D3116-3-0520 SEAL PER IIN-D412-694.

ADD THE FOLLOWING PARTS TO THE LIST OF IIN-D412-694. CUSTOMERS WITH EARLY MODEL D412-694-011 KITS CAN PROCURE THE DSI 9309-011 KIT FROM DART TO DO THIS MODIFICATION.

-011	Part Number	Description
X	D412-694-011	SPACEDOOR MODIFICATION
X	DSI 9309-011	SEAL KIT
2	D3116-9-0520	SEAL
2	D3144-15	DOUBLER
48	BSP45	RIVET

### PROCEDURE:

- 1) LOCATE D3116-9-0520 SEAL ON D412-694-01/-02 DOOR ASSEMBLY SO THAT IT WILL REST AGAINST EXISTING AIRCRAFT SEAL WHEN DOOR IS CLOSED. ENSURE PROPER ORIENTATION OF SEAL.
- 2) TRIM D3144-15 DOUBLER AND D3116-9-0520 SEAL AS NECCESARY TO CLEAR BRACKETS ON AFT EDGE OF DOOR. ENSURE MINIMUM EDGE DISTANCE OF 0.40" (10 mm) FROM THE RIVET HOLES.
- 3) TRANSFER DRILL Ø0.129" (#30) FROM DOUBLER, THROUGH SEAL AND INTO THE DOOR. DEBURR AND INSTALL DOUBLER & SEAL USING BSP45 RIVETS. SEAL RIVETS WITH RTV-732 SEALANT.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

### **APPROVED**

BY:   
D. SHEPHERD (DE # 02)

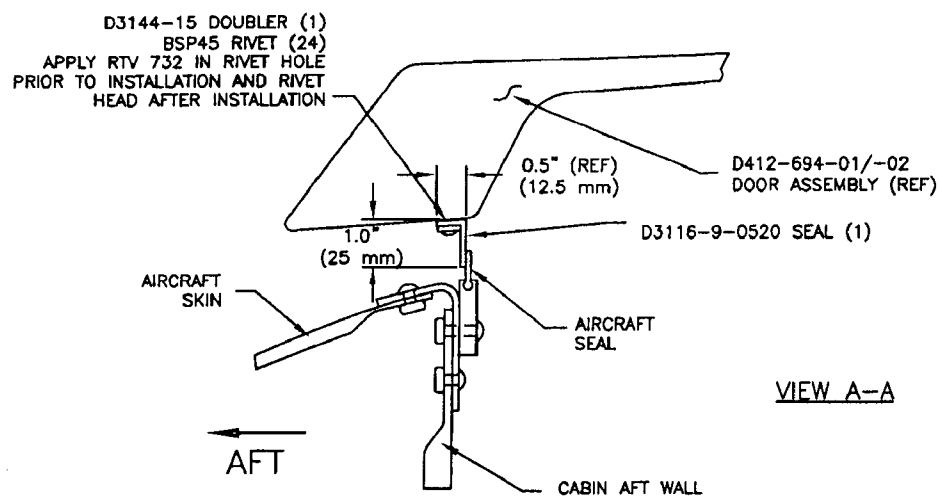
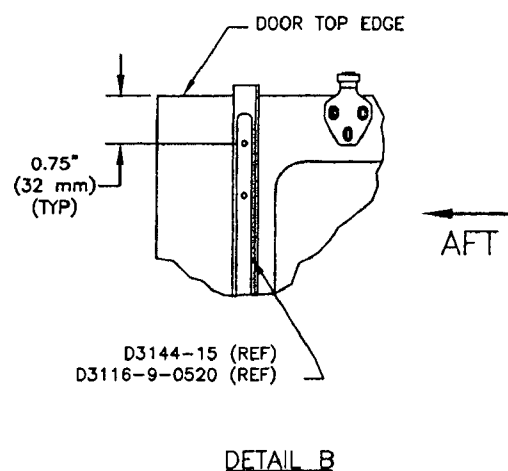
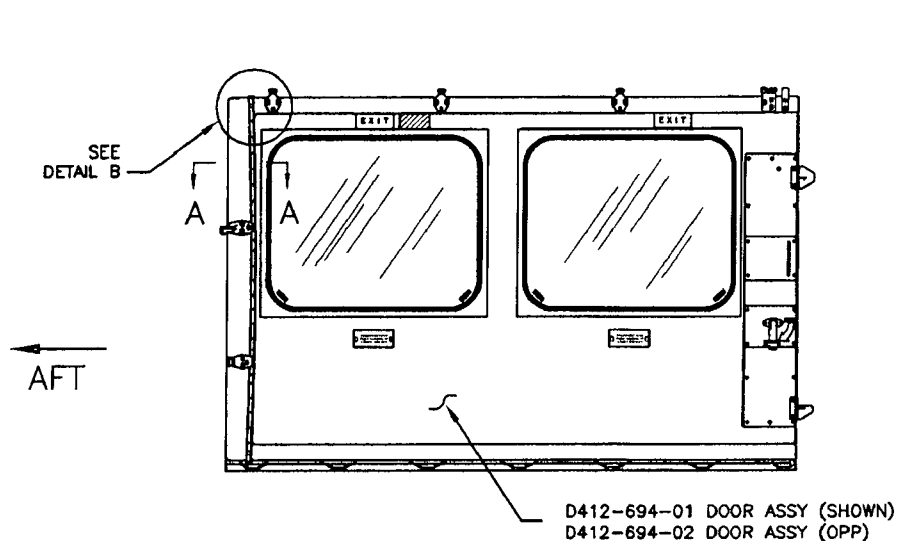
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CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b>	
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